

Friday, September 23, 2016 2:48:39 PM

151361

Item ID: D2366

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Lock Handle

Stop

NS2

Start Date: 9/20/2016 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 9/23/2016 **Req'd Qty:** 12.00

12

Customer:

Reference:

DAS

Approvals: **Process Plan:**

21
9-89

Date: SEP 26 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

Work Order ID 151361

Friday, September 23, 2016 2:48:39 PM

151361

Page 2

Item ID: D2366 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lock Handle
 Start Date: 9/20/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 9/23/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					(12)			22 16/09/29
Small Fab	Memo	0.00							
Small Fab	Tumble and stock								
140	Identify as per dwg & Stock Location: <u>St006</u>	0.00				12			
140									
Packaging	Memo	0.02							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.20							
Quality Control									

VS 16/10/00

DAS
21
9-89

OCT 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
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<table style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> <th colspan="4" style="text-align: left; padding: 5px;">FAULT CATEGORY</th> </tr> <tr> <td style="width:15%; padding: 5px;">Environment ☐</td> <td style="width:15%; padding: 5px;">☐ No Re-verification</td> <td style="width:15%; padding: 5px;">☐ Pressure/Forced</td> <td style="width:15%; padding: 5px;">☐ Temperature/Cure</td> <td style="width:15%; padding: 5px;">☐ Power Loss/Surge</td> <td style="width:15%; padding: 5px;">☐ Positioned Wrong</td> </tr> <tr> <td style="padding: 5px;">Design ☐</td> <td style="padding: 5px;">☐ Operator</td> <td style="padding: 5px;">☐ Bending</td> <td style="padding: 5px;">☐ Set-up</td> <td style="padding: 5px;">☐ Folio/Program</td> <td style="padding: 5px;">☐ Outside Dimensions</td> </tr> <tr> <td style="padding: 5px;">Doc/Data ☐</td> <td style="padding: 5px;">☐ Offset/Setup</td> <td style="padding: 5px;">☐ Centre Not Concentric</td> <td style="padding: 5px;">☐ BOM/Route</td> <td style="padding: 5px;">☐ Grain</td> <td style="padding: 5px;">☐ Over/Under tolerance</td> </tr> <tr> <td style="padding: 5px;">Equip/Tooling ☐</td> <td style="padding: 5px;">☐ Supplier</td> <td style="padding: 5px;">☐ Cracks</td> <td style="padding: 5px;">☐ Broken/Damage/Defect</td> <td style="padding: 5px;">☐ Weld</td> <td style="padding: 5px;">☐ Part Incorrect</td> </tr> <tr> <td style="padding: 5px;">Handling/Pre ☐</td> <td style="padding: 5px;">☐ Training</td> <td style="padding: 5px;">☐ Crimp/Kink/Ripple/Wave</td> <td style="padding: 5px;">☐ Inspection Incomplete/Unqualified</td> <td style="padding: 5px;">☐ Wrong Stock Pulled</td> <td style="padding: 5px;">☐ Part Lost/Missing</td> </tr> <tr> <td style="padding: 5px;">Material ☐</td> <td style="padding: 5px;">☐ Use for Testing</td> <td style="padding: 5px;">☐ Cuffs</td> <td style="padding: 5px;">☐ Contamination</td> <td style="padding: 5px;">☐ Out of Sequence</td> <td style="padding: 5px;">☐ Part Moved</td> </tr> <tr> <td style="padding: 5px;">Internal Transport ☐</td> <td style="padding: 5px;">☐ Poor Information</td> <td style="padding: 5px;">☐ Crushing</td> <td style="padding: 5px;">☐ Countersink</td> <td style="padding: 5px;">☐ Off-set</td> <td style="padding: 5px;">☐ Drawing</td> </tr> <tr> <td style="padding: 5px;">Tribal Knowledge ☐</td> <td style="padding: 5px;">☐ Rushing</td> <td style="padding: 5px;">☐ Heat Treat</td> <td style="padding: 5px;">☐ Cut Too Short</td> <td style="padding: 5px;">☐ Mislabeled</td> <td style="padding: 5px;">☐ Finish</td> </tr> <tr> <td style="padding: 5px;">LOA ☐</td> <td style="padding: 5px;">☐ Product Improvement</td> <td style="padding: 5px;">☐ Wave/Twist in Tube</td> <td style="padding: 5px;">☐ Instructions Incomplete/Unclear</td> <td style="padding: 5px;">☐ Fit/Function</td> <td style="padding: 5px;">☐ Misread</td> </tr> <tr> <td style="padding: 5px;">Substation ☐</td> <td style="padding: 5px;">☐ Process Improvement</td> <td style="padding: 5px;">☐ Marks/Chatter</td> <td style="padding: 5px;">☐ Drill Holes</td> <td style="padding: 5px;">☐ Misaligned/off center</td> <td style="padding: 5px;">☐ Turning Sequence</td> </tr> <tr> <td style="padding: 5px;">Past Expiry Date ☐</td> <td style="padding: 5px;">☐ Manufacturing Process</td> <td colspan="4" rowspan="2" style="padding: 5px; vertical-align: top;">OTHER : _____</td> </tr> <tr> <td style="padding: 5px;">Misidentified ☐</td> <td style="padding: 5px;">☐ Past Due</td> </tr> </table>								Root Cause				FAULT CATEGORY				Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____				Misidentified ☐	☐ Past Due
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Picklist Print

Friday, September 23, 2016 2:48:39 PM

Page 1

Work Order ID: 151361

151361

Parent Item: D2366

D2366

Parent Item Name: Lock Handle

Start Date: 9/20/2016

Required Date: 9/23/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B00.05.04ReformatEC
IPP Rev:C Now on Waterjet 07-04-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	165.0210	0.0174	0.21979			

M304S20GA

PR 16/09/27

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

161.8

m134495

2.4

m134982

1.6

m135327

93.8

m135689

64

MAT20

3.221

m133901

3.221

0.3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

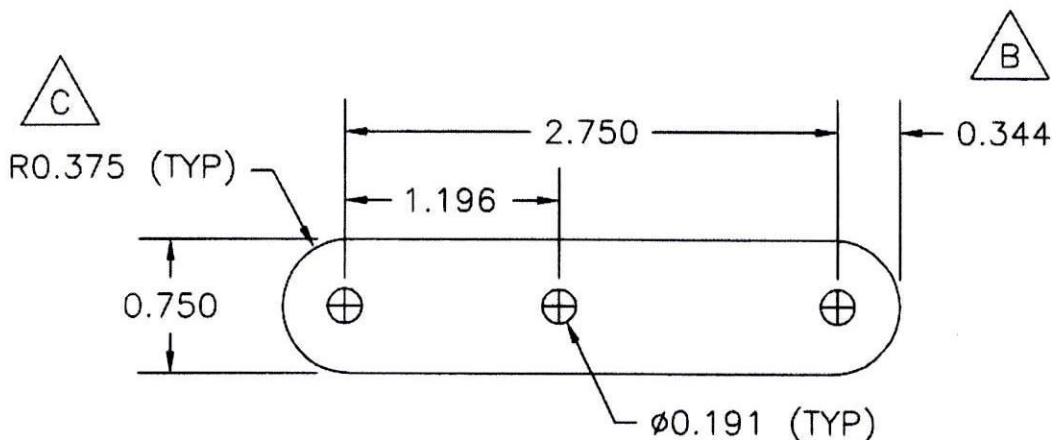
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2366	REV. C SHEET 1 OF 1
DATE 00.04.24		TITLE LOCK HANDLE	SCALE 1:1
A	95.02.20	NEW ISSUE	
B	96.06.10	R0.50 WAS R0.354; 0.344 WAS 0.300	
C	00.04.24	R0.375 WAS R0.50	

RELEASED
00.05.02 H



SHOP COPY
RETURN TO
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WORK ORDER
NO. 151361 MCS
1609-26

MATERIAL: AISI 304/316 SS 0.040 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE INCHES

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